

SHIP TODAY 10/08/09

PRELIMINARY ISSUE



Work Order ID 61029

August 4, 2010 10:36:19 AM

Page 1


Item ID: D4078-1 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Clamp Half


Start Date: 04/08/2010 Start Qty: 2.00  Cust Item ID:
Required Date: 08/08/2010 Req'd Qty: 2.00  Customer: 

Reference: PA 10-08-04
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4078	PA1

100	0.00								
 Bandsaw	Memo	0.00	2.8	10/08/08		2	0		
Jeaspa Bandsaw	Cut blank 2.700" long								

110	0.00								
 HAAS 1	Memo	0.00	2.8	10/08/08		2	1		
HAAS CNC vertical machine #1	Mill as per Dwg and Folio FA929 Folio rev: <u>PBT 4A</u> Dwg Rev: <u>PBI</u>								

Deburr



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D24078-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 7 Date: 100810
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>61029</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/08/08</u>	<u>110</u>	<u>Radius of .480 was change</u> <u>for Radius .380⁺⁰¹_{-0.00} but</u> <u>Program was not Modified</u> <u>R.E. Program ERROR</u> <u>new per. not Panel.</u>	<u>JSun</u>	<u>Scrap Replacer</u> <u>Batch 110001</u>	<u>JS</u> <u>10/08/09</u>	<u>S</u> <u>10/08/09</u>	<u>JSun</u>	<u>1008.09</u>

NOTE: Date & initial all entries

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Required Date:	08/08/2010	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		10/08/09		2	1		
130 QC Quality Control	QC8- Inspect parts - second check Memo <input type="checkbox"/>	0.00 0.00		- inspect to PBI Dry only 8/10/09					
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				m/	10	08	09 (2)

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Required Date:	08/08/2010	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	






Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Powdercoat Powder Coating	M112588 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 START: 11:30AM Temp: 320°F Fin: 12:00PM Memo	0.00 ⇒ 9H 0.00		10/08/09		X2	0		
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				10/8/9	5	20	
170 Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00				10/8/9	5	20	



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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

POSITIVE RECALL
EFFECTIVE 10-8-9 AUTH h
RELEASED _____ DATE _____

PPD 336 Aug

mkf
10-8-9

Picklist Print

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Work Order ID: 61029



Parent Item: D4078-1



Parent Item Name: Clamp Half

Start Date: 04/08/2010

Required Date: 08/08/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev:A, New Issue 10-05-07 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	14.3332	0.223	0.469474			



6061-T6 Bar 1.25 x 1.25



Location

Loc Qty

Loc Code

MAT03

14.33315053

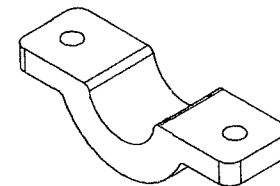
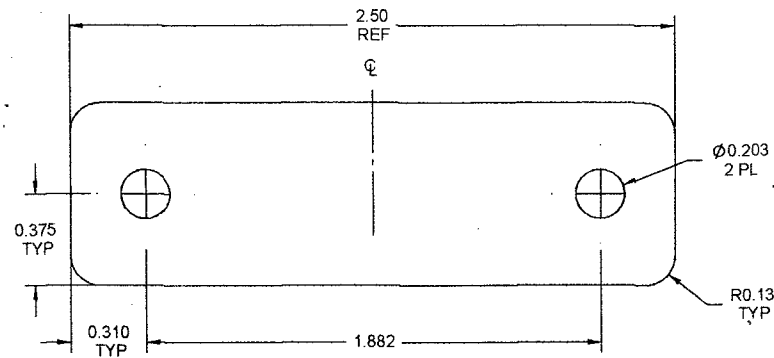
106259

7.06921053

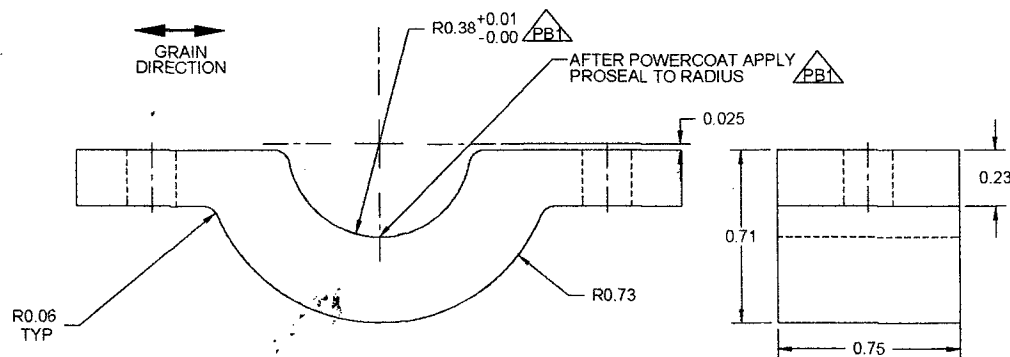
110001

7.26394

.4695 28 10/08/08
+ .2347 scrap parts



w/o 61027
61029



D4078-1 CLAMP HALF

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4078-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

PB1	R0.38 was R0.48, ADDED PROSEAL NOTE.	VB	10.07.30
A	NEW ISSUE	VB	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN	VB		
DRAWN	VB		
CHECKED	VB		
MFG. APPR.	VB		
APPROVED	VB		
DE APPR.	VB		
DATE	10.07.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4078	REV. PB1 SHEET 1 OF 1
TITLE CLAMP HALF	SCALE NTS
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Kim Johnston

From: David Shepherd [dshepherd@dartaero.com]
Sent: Wednesday, August 11, 2010 6:46 PM
To: 'Kim Johnston'
Subject: RE: prelim work orders, D4079-1 B61027 and D4078-1 B61029

Yes ... They will be scrapped afterwards or used for Show purposes.

David

-----Original Message-----

From: Kim Johnston [mailto:kjohnston@dartaero.com]
Sent: Tuesday, August 10, 2010 9:02 AM
To: David Shepherd
Subject: prelim work orders, D4079-1 B61027 and D4078-1 B61029

Hi David,

I have two prelim work orders, D4079-1 B61027 and D4078-1 B61029. Mike tells me that they were sent to you for testing? Can you confirm this for me by email and let me know if they will be scrapped after. I'll attach your email to the work orders and file them. Thanks,

Kim Johnston
Dart Aerospace Ltd.
Engineering Clerk
Document Control
1270 Aberdeen Street
Hawkesbury, Ontario, K6A 1K7
Email: kjohnston@dartaero.com
Tel: 613-632-5200
Fax: 613-632-9311

No virus found in this incoming message.

Checked by AVG - www.avg.com

Version: 8.5.441 / Virus Database: 271.1.1/3061 - Release Date: 08/09/10 18:35:00